

Date: Tuesday, 10/3/2006 2:51:19 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BEARING ASSEMBLY
Job Number	28836	Part Number	D3183045
Estimate Number	11136	Drawing Number	D3183 REV:C1
P.O. Number	N/A	Project Number	N/A
This Issue	10/3/2006	Drawing Revision	C1
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	10/20/2006
Previous Run	28721	Qty:	20
Written By	125		
Checked & Approved By	Um: Each		
Comment	Est A04.02.18 New issue KJ/DS		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR1000	Delrin Round Bar 1"	
			
Comment: Qty.: 0.0350 f(s)/Unit Total: 0.6993 (s) Delrin Round Bar 1" Material: Ø1.00 Delrin Rod (M-DELRIN-R1.000) Identify as D3183-9 Batch: 101078 TSG 06.10.07			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL Turn D3183-9 Cap as per Folio FA388 Deburr TSG 06.10.07			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE TSG 06.10.07 125			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK SD 06.10.08 125			
5.0	D31835	Bearing	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) 26 Pick: Qty Part Number Description Batch 24 1 D3183-5 Bearing ml 06/10/13			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/10/18
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 2:51:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 28836

Part Number: D3183045

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

6.0 A



See Bottom

Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

mf 06/10/13

26

7.0 QC5

INSPECT WORK TO CURRENT STEP



6.10.16 26

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~ST 412~~ ST 412 ~~Stocked~~

~~Stocked~~ Boe/10/17 26

26

9.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/18

26

Job Completion



6.10.18

6.0^B Make 26 assy D 3183-045

dr u

Put Back in stock 90 of D3183-9 Cap ST 412
B 28836

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28836
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>36</u>	Audited by: <u>SA</u>	Prototype Approval:	N/A
Date: <u>06.10.07</u>	Date: <u>06.10.07</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	<i>[Signature]</i>



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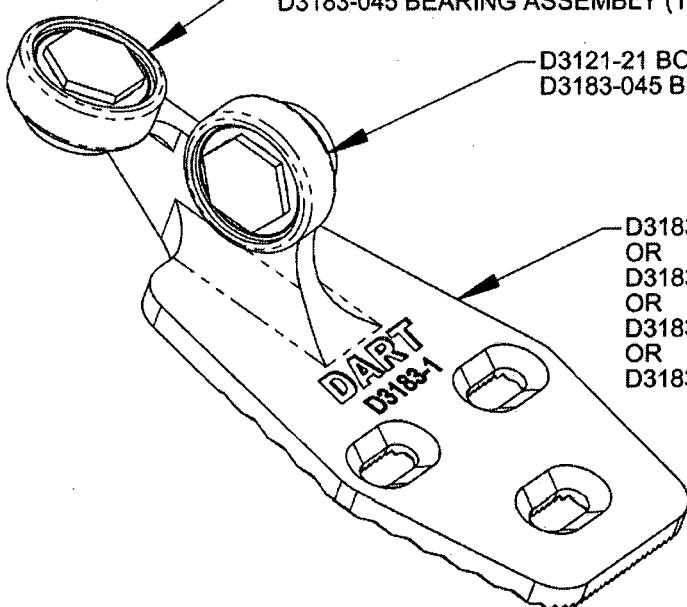
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4
DATE	04.02.17	TITLE	SCALE
		BRACKET ASSEMBLY	1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/9; 0.182 WAS 0.431	
C1	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01

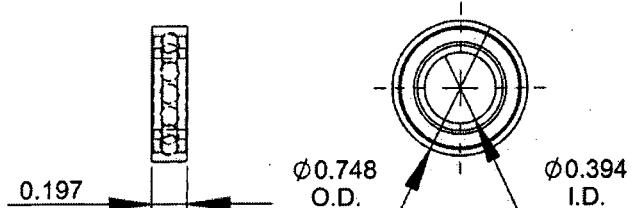
D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)

D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)

D3183-1 BRACKET FOR -041 (SHOWN)
OR
D3183-2 BRACKET FOR -042 (OPPOSITE)
OR
D3183-3 BRACKET FOR -043 (SIMILAR)
OR
D3183-4 BRACKET FOR -044 (SIMILAR)



D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)

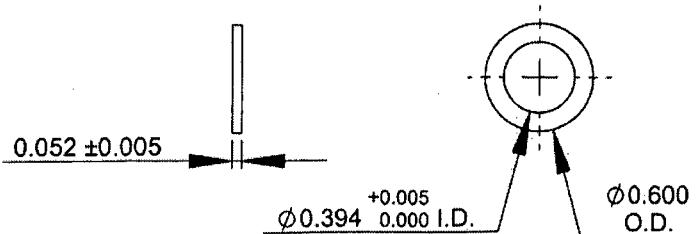


D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 680022
- 3) ALL DIMENSIONS ARE IN INCHES

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28836



D3183-7 WASHER

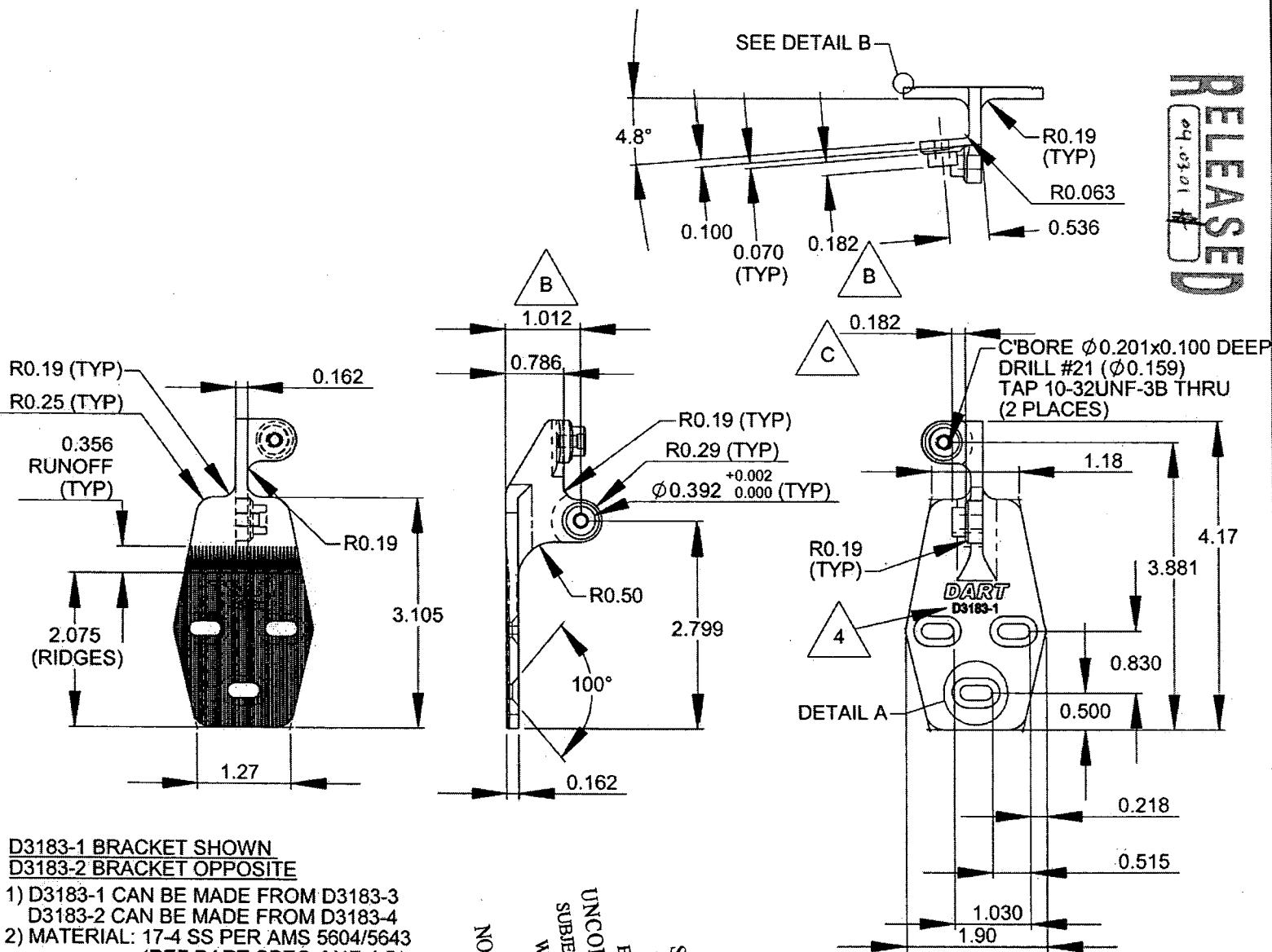
- 1) MATERIAL: AISI 303 ROUND BAR (M303R)
ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES



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DATE	04.02.17	TITLE BRACKET ASSEMBLY
		SCALE 1:2

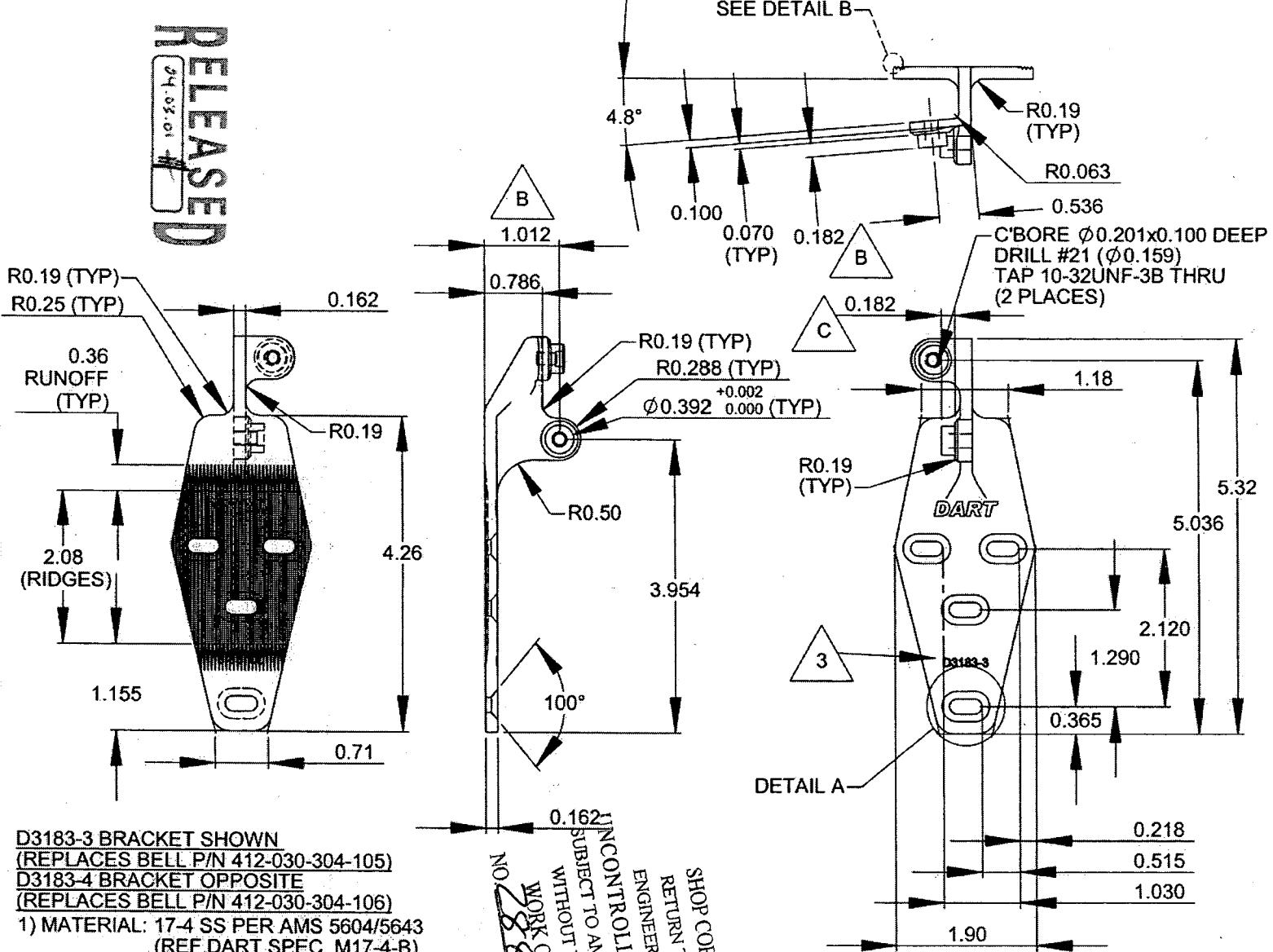
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03183-1

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		D3183
DATE	04.02.17	TITLE
		BRACKET ASSEMBLY
		SHEET 3 OF 4
		SCALE 1:2



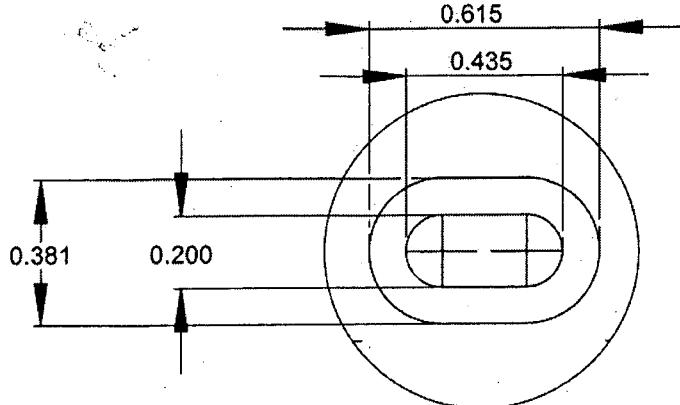
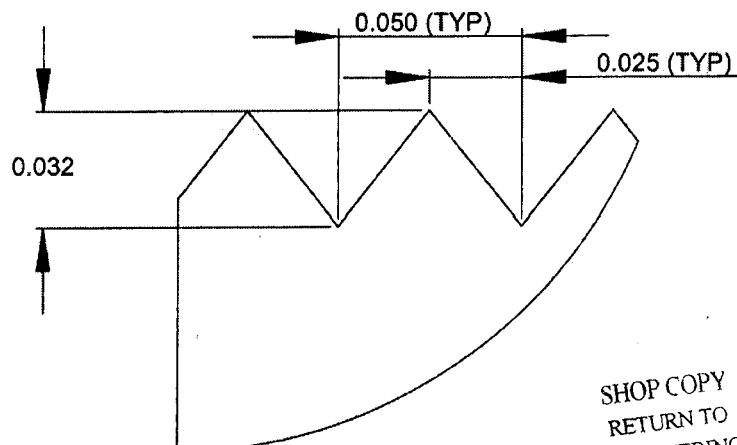
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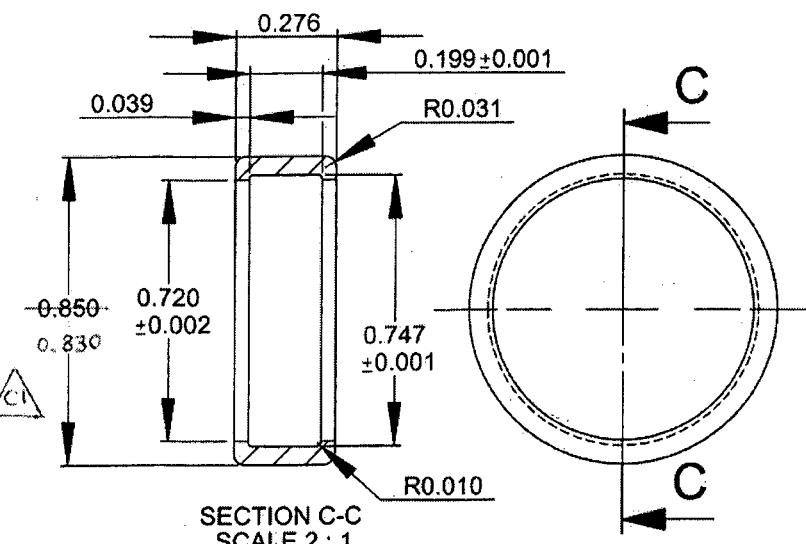
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 4 OF 4

DATE 04.02.17 TITLE BRACKET ASSEMBLY SCALE 1:1

DETAIL A (2 : 1)**RELEASED**
04.03.01DETAIL B (20 : 1)

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WORK ORDER
NO. 28836

**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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